

Final Report

WATER CONSERVATION STUDY

**BADGER ARMY AMMUNITION PLANT
BARABOO, WISCONSIN**

Prepared for

Department of the Army
U.S. Army Engineer District
Omaha, Nebraska

Under

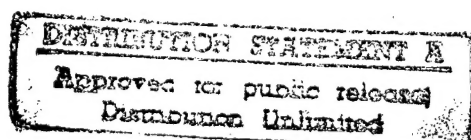
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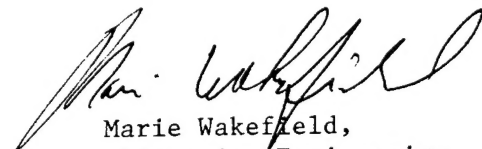


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LIST OF ABBREVIATIONS

A	-	ampere
BAAP	-	Badger Army Ammunition Plant
COE	-	Corps of Engineers
CY	-	cubic yards
ECIP	-	Energy Conservation Investment Program
ECO	-	Energy Conservation Opportunity
EMC	-	E M C Engineers, Inc.
F	-	Fahrenheit
ft	-	foot, feet
ft ²	-	square feet
gal	-	gallons
gpd	-	gallons per day
gpm	-	gallons per minute
hp	-	horsepower
hr	-	hour
in	-	inch
IRM	-	Pump and Treat Facility
kgal	-	kilo-gallon, one thousand gallons
kW	-	kilowatt, one thousand watts
kWh	-	kilowatt-hours, one thousand watt-hours
LCCA	-	Life Cycle Cost Analysis
LF	-	linear foot (feet)
MES	-	M.E. Simpson Co., Inc.
mi	-	mile(s)
O&M	-	operation and maintenance manual
rpm	-	revolutions per minute
SIOH	-	supervision, inspection and overhead
SIR	-	Savings-to-Investment Ratio
SOW	-	scope of work
SPB	-	simple payback

temp	-	temperature
UPW	-	Uniform Present Worth factor
yr	-	year(s)

EXECUTIVE SUMMARY

INTRODUCTION

Authorization for Study

This study was conducted and this report prepared under Contract No. DACA01-94-D-0033, Delivery Order No. 0004. The contract was issued by the Department of the Army, Mobile District, Corps of Engineers, to E M C Engineers, Inc. (EMC).

Purpose of Study

The purpose of this water conservation study is to identify projects which will result in energy maintenance and cost savings in the process water distribution system at Badger Army Ammunition Plant (BAAP) in Baraboo, Wisconsin.

Method of Analysis

Specific work required includes:

1. Perform a limited site survey of the process water system to collect data required to evaluate specific energy conservation opportunities (ECOs).
2. Conduct a thorough survey of the process water system using state-of-the-art underground leak detection equipment on all piping 6 inches and larger.
3. Develop a process water map which shows the location and estimated quantity of leaks identified during the leak detection survey.
4. Evaluate specific ECOs to determine energy savings potential and economic feasibility.
5. Provide project documentation for recommended ECOs.
6. Prepare a report to document work performed, and to describe the results and recommendations of a site and energy audit and the leak detection study.

This study does not include an audit of the potable or raw water system at BAAP.

LEAK DETECTION SURVEY

A leak detection survey was performed on all process water piping with a diameter of 6 inches or greater. The leak detection analysis was performed using a combination of listening devices and preamplified-transducer systems to identify the majority of leak locations. When the location of the leak could not be readily identified using these

methods, a leak correlator was used. The leak correlator determines leak location based on the time it takes for sound to travel from the leak to a waterline connection point.

Sixty-four leaks were identified by the survey on the water mains within the project scope area. The estimated leakage of 194,500 gallons per day (gpd) was separated into the following types of leaks:

- Fifty fire hydrant leaks at 37,500 gpd
- Five main line leaks at 143,000 gpd.
- Eight valve leaks at 11,000 gpd.
- One service line leak at 3,000 gpd.

ENERGY CONSERVATION OPPORTUNITIES

The majority of water usage in the process water system is due to leakage. ECOs were evaluated that would serve to reduce leakage, thereby reducing pumping, chemical treatment, and maintenance costs.

Description of ECOs

Four ECOs were identified to reduce leakage in the process water system. These four ECOs are:

- ECO #1. Implement a water audit and leak detection program.
- ECO #2. Clean and reline with cement four lines designated by BAAP personnel as having historically high occurrences of leakage.
- ECO #3. Isolate piping that is located in areas classified as "Caretaker" areas. "Caretaker" areas consist of a number of buildings identified by BAAP personnel which do not require maintenance. Fire protection would only be provided along the perimeter of "Caretaker" to inhibit the spread of fire to those areas not designated "Caretaker".
- ECO #4. Implement a water audit and leak detection program, taking into account the effects of implementing ECO #2 and #3 on the process water system.

Economic Analysis

The economic analysis of the ECOs is summarized in Table 1.

Table 1. Summary of ECOs

ECO No.	Description	Investment Cost	Annual Water Savings*	Total Disc. Savings	SIR	Payback (yrs)
1	Implement Leak Detection	\$20,160	116.73	\$524,574	30.34	0.49
2	Reline Design. Main Lines	724,676	54,636	1,278,139	1.76	8.45
3	Isolate Caretaker Areas	71,403	18.73	438,211	6.14	2.43
3A	Isolate Area #8	13,654	2.75	64,374	4.71	3.16
3B	Isolate Area #1	8,324	1.00	23,411	2.81	5.30
3C	Isolate Area #12	5,351	3.13	73,152	13.67	1.09
3D	Isolate Area #13	13,676	1.20	28,143	2.06	7.25
3E	Isolate Area #9	13,589	1.46	34,061	2.51	5.95
3F	Isolate Area #18	16,807	9.20	215,094	12.80	1.17
4	Leak Detection After #2,#3	17,640	61.71	323,356	18.33	0.82

*Annual Water Savings are in units of millions of gallons saved per year

ECO Nos. 1, 2, 3 and 4 all display favorable economic payback. That is, they all have SIRs greater than 1.25 and simple paybacks of 10 years or less. Based on the qualifications listed by the Scope of Work, all of the ECOs qualify for government energy conservation funding programs.

RECOMMENDATIONS

The following ECOs are recommended for implementation:

- **ECO #1. Implement a leak detection program**, including a water audit, every two years as recommended by AWWA Manual 36. Continue with BAAP's policy to immediately excavate and repair all leaks discovered by the leak detection surveys.
- **ECO #2. Clean and reline with cement** the following main lines:
 1. 24-inch diameter pipe that runs along coordinate East 2,023. This section starts at Valve 368 to the north and ends at Valve F-9 to the south. The pipe has a total length of 2,644 feet and supplies 10 branches.
 2. 24-inch diameter pipe that runs along coordinate East 3,013. This section starts at Valve 281 to the north, and ends at Valve F-11 to the south. This pipe has a total length of 2,244 feet and supplies 12 branches.
 3. 14-inch diameter pipe that runs along coordinate East 4,885. This section starts at Valve 268 to the north and ends at Valve 341 to the south. The pipe has a total length of 2,870 feet and supplies 38 service branches.

4. 14-inch diameter pipe that runs along coordinate East 4,215. This section starts at Valve 204 to the north and ends at Valve 242 to the south. The pipe has a total length of 2,440 feet and supplies 22 branches.

These pipe lengths were chosen based upon evaluation of leakage frequency by BAAP personnel. The grand total of pipe to be cleaned and relined is 4,890 feet of 24-inch diameter steel pipe, and 5,310 feet of 14-inch diameter steel pipe.

- **ECO #3. Isolate process water piping** in "Caretaker" Area No. 1, 8, 9, 12, 13, and 18. If this ECO is implemented, special care must be taken that the buildings in these areas remain in "Caretaker" status. If, in the future, buildings are taken off "Caretaker" status, fire protection must be restored to those buildings.
- **ECO #4. Implement a leak detection program**, including a water audit, as recommended in ECO #1. However, this ECO should only be considered if ECO #2 and #3 are implemented first.

Note that the recommendations and programming documentation for ECO #1 and #4 are identical except that ECO #1 is based on current process water system conditions and EO #4 is based on the estimated condition of the process water system after ECO #2 and #3 are implemented. BAAP personnel should determine the appropriate time to submit either ECO #1 or ECO #4 for government funding.

Budget 1991, West

ECO#	Water Savings in thousands of gals/yr	Annual Savings, \$
1	116.73	40,740
* 2	51,636	85,724
* 3	18.73	29,390
20	2.75	
21	1.00	
22	3.13	
23	1.20	
24	1.46	
25	9.20	
* 4	61.71	21,536
TOTALS for 2, 3, & 4	54,717	136,650



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FM: Michael Scholz**DT:** 16 May 1995**PROJECT:** Water /Energy Conservation Study-
BAAP**CONTRACT NO.:** DACA-94-D-0033**EMC NO.:** 1406-004

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Sincerely,

cc: S. Owens

Signed: